

Date: Friday, 9/29/2006 10:43:26 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 28791D		
Estimate Number	: 10356		
P.O. Number	: N/A	Part Number	: D2279
This Issue	: 9/29/2006 S.O. No. : N/A	Drawing Number	: D2279 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A	Drawing Revision	: D
Previous Run	: 27756D	Material	: N/A
Written By			
Checked & Approved By			
Comment	Est Rev: A New Issue 05-11-07 JLM Est Rev:B Now on Waterjet 06-07-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M2024T3S040	2024-T3 .040 sheet
		Comment: Qty.: 0.1544 sf(s)/Unit Total : 3.0870 sf(s) Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick (M2024T3S.040) Identify as D2279 Batch: M102448
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D 2279 Dwg Rev: B D Prog Rev: D
		<i>SAD 06:10:28 20</i>
		Comment: 2-Deburr if necessary
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>SAD 06:10:28 20</i>
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK <i>Job 10:30 (20) counted</i>
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE Form As per Dwg D2279 <i>SB 06/11/20 28</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 06/11/27
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 9/29/2006 10:43:27 AM
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Drawing Name: STEP SPACER

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Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10/06/11/20 (20)

7.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



FC

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

YL

06/11/22 X 20

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/11/23 (20)

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB 06/11/23 20

10.0 QC21 FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 06/11/27

Job Completion



10/06/11/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	28791 D
Description: Step Spacer	Part Number:	D2279
Inspection Dwg: D2279	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<u>Sally</u>	Audited by:	<u>JL</u>	Prototype Approval:	N/A
Date:	<u>06/10/29</u>	Date:	<u>06/10/30</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue	P/O D2582	KJ/JLM ✓ <i>[Signature]</i>

DART

DESIGN
B/W
DRAWN BY
GP
HAWKESBURY, ONTARIO, CANADA
REV. D

CHECKED
RE
APPROVED
MH
DRAWING NO.
D2279

SHEET 1 OF 1

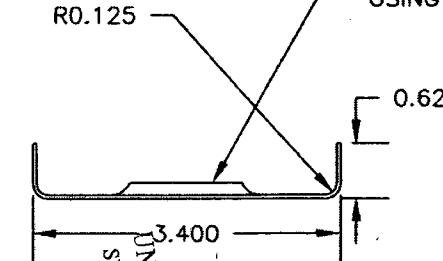
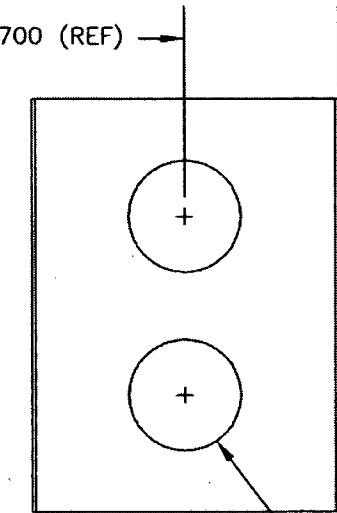
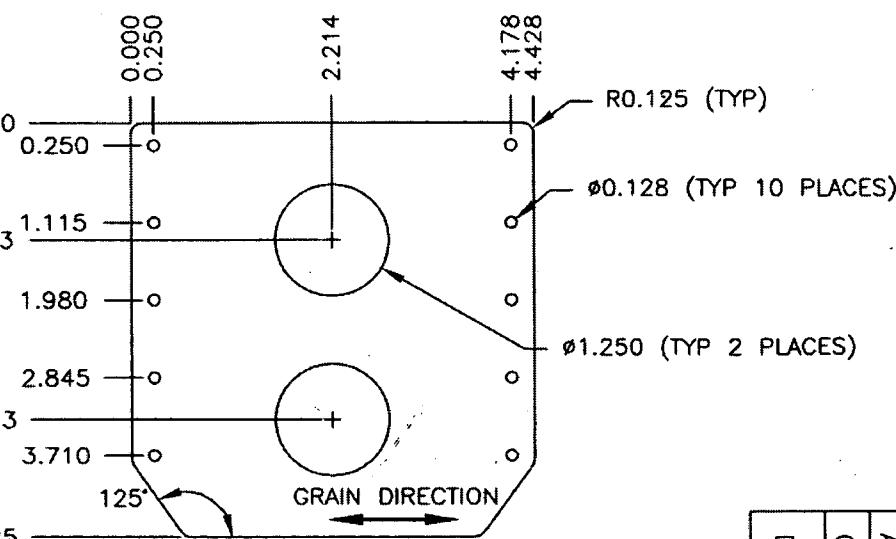
SCALE
1:2

DATE	98.10.05	STEP SPACER	
A	94.10.13	NEW ISSUE	
C	94.11.15	0.588 WAS 1.607 AND 3.861 WAS 4.881	
D	98.10.05	4.428 WAS 4.460, 0.040 WAS 0.032 CHANGES PER TSR A912	

RELEASED
98.10.08 DS

UNDER REVIEW

10/23/98 GP
DESIGN OK, BUT CHECK WITH
MANUFACTURE
OK. GP, 10/23/98



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28791 D

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

